Work Orde Tuesday, Octobe					H (4)	,					Page 1
Revision ID:	K10003 Saddle, D205-6	534-011		Accept				s	etup Star	1 (30)(4) 11	
Start Date: Required Date: Reference:	10/12/2010 10/22/2010	Start Qty: 4.00 Req'd Qty: 4.00			Cust Item II Customer:	D:					
Approvals:	Process Plan	n:	Date:	Tooling: SPC (Y/N):	.	nte:		R	tun Sta Sto		
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr		sion Nbr								,	
IIN634,635	Rev	F									
DC Document Control		DOCUMENT CONT Memo Create W	ROL Thite labels only per PPP K1000	0.00 0.00 03 CHG 007	Sidulos		Vire V	Su	They	10/11	102
110 Packaging Packaging		Pick Kit Memo		0.00					[]/oj	11/62	(4)
120 QC Quality Control		QC4- 100% Inspect k	tits for completeness	0.00	oluloz			(41))		

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W/O:		WORK ORDER CHANGES							
DATE	STEP	PRO	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No	:	PAR #:	Fault Category:	NCR: Yes	No DO	Δ.	. Date:		

Resolution: _____ Disposition: ____ QA: N/C Closed: ____ Date: ____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)										
		Description of NC		Corrective Action Section B	Verification	Approval	Approval					
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	QC Inspector				
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Work Order ID 62888

Tuesday, October 12, 2010 1:07:59 PM



Page 2

Item ID:

K10003

Accept

Setup Start

Revision ID:

Item Name:

Saddle, D205-634-011

Start Date:

10/12/2010

OC:

Start Qty: 4.00

Required Date: 10/22/2010

Req'd Qty: 4.00



Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Operation

Description

Date:_____ Date: _____

Tooling:

SPC (Y/N):

Date: Date:

Start Run

Stop

Stop

Sequence ID/ Work Center ID

130

Packaging

Memo

0.00

0.00

Set Up/ Run Hours

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number

Stamp

Packaging

140

Quality Control

OC21- Final Inspection - Work Order Release

Identify as per dwg & Stock Location:

Memo

0.00

0.00

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W/O:		WORK ORDER CHANGES								
DATE	STEP	PR	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No):	PAR #:	Fault Category:	NCR: Yes	No DQ	Δ:	Date:			

Part No:	_ PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
Resolution:	<u> </u>	Disposition:	QA: N/C Closed:	Date:

NCR:	R: WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B	Verification	Approval	Approval		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date '	Section C	Chief Eng	QC Inspector	
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Picklist Print

Tuesday, October 12, 2010 1:08:04 PM

Work Order ID: 62888

K10003 Parent Item:

Parent Item Name: Saddle, D205-634-011



Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP: I□ 03.01.16 Reformat: Incorporated D205-641-011

IPP: J 06-07-25 As per DSI 9344

IPP: K 06.11.17 Per K10003 Rev C

KJ IPP: L 07.01.12 Document Record for copying bluefile rmv KJ IPP Rev:M 08-08-12 now @ chg 006 (DSI 9418) DD verified by:

IPP N 09.01.27 DSI 9418 rev B EC verified by: DD

Purchased

No

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch		Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-51A		Purchased	No			110	Each	231.0000	8 - 1	^{' 32} (1	
1 Bolt													

Location Loc Qty ST360 31 114941 31 ST361 200 115316 200

KJ/RF□

JLM

115457

110 Each

500

1,000.000

Loc Code

16



Location	Loc Qty	Loc Code
ST356	1000	
112933	96	
113149	17	
114523	2	
114615	1	
114941	84	
115108	300	

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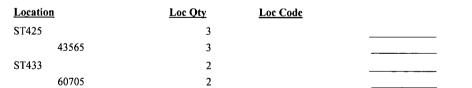
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Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date:	<u> </u>
		esolution:			i				
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DATE	STEP	Description of NC		Corrective Action Secti			cation Approval		Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		ion C	Chief Eng	QC Inspector
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	Work Order ID: 62888 Parent Item: K10003 Parent Item Name: Saddle, D205-634-0	111		11 18 1 18 1 18 1 18 1 18 1 18 1 18 1			St	art Data	10/12/2010	Paguiro	d Date: 10/22/2010
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Sp				115231 115358 115518 11536	<u>Lo</u>	75 7 8 40 20	Loc Code		M1/53 M1/53	- DF e p	
Sp	AN6-12A	Purchased	No		110	Each	136.0000	8	32		
			<u>L</u>	ocation	Lo	e Qty	Loc Code				
			S	Г342 114941 115767		136 86 50			11149	4/	
54	AN960JD416 NAS1149D0463J Washer	Purchased	No		110	Each	24.0000	32.3	128 L M/16	038	
				ocation Γ300 113288	<u>Lo</u>	24 24	Loc Code			_	
Szh	AN9601D616 NAS1149D0663J 	Purchased	No		110	Each	0.0000	8	32 M 1/ S	618	Cup 11/03 (4)

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W/O:			WORK ORDER CHANGES								
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Part No: PAR #: Resolution: NCR:		PAR #:	Fault Categ	NCR: Yes	No DG	A:	Date:				
		esolution:	Disposition	:	QA: N/C C	losed:		Date: _	·		
		•	WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC		n B	Verif	cation	Approval	Approval			
DATE		STEP Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sec	tion C	Chief Eng	QC Inspector		
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Tuesday, October 12, 2010 1:	08:04 PM							
Work Order ID: 62888								7
Parent Item: K10003			i i i i i i i i i i i i i i i i i i					
Parent Item Name: Saddle, Da	205-634-011		*** (1917 \$9:11 BOINT \$0;00 1111 108)			Start Date Start Qty	e: 10/12/2010 v: 4.00	Required Date: 10/22/2010 Required Qty: 4.00
D2570 Bushing	Manufactured	No		110	Each	215.0000 2	4- 96	
			Location	Le	e Oty	Loc Code		
			ST018		215			
•			60476		201		60476	>
D2521	N4 C 1	Ma	61985	110	14	15 0000		
D2571 ,	Manufactured	No		110	Each	15.0000	62//	
1			Location	<u>L</u> c	oc Qty	Loc Code		_
			ST425		7			
			43564		3			
			47564		4			
			ST433		8			
			58250 61332		3 5			
D2572	Manufactured	No	01332	110	5 Each	5.0000	1 4	
Saddle, Fwd In 205	ivianuraetureu	110		110	Lucii		62157	Cufup G



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		W	ORK ORDER CH					•	
STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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•	PAR #:	Fault Category:			R: Yes	No DQ	A:	Date:	
Resolution:			Disposition:			QA: N/C Closed: Date: _			
		WORK OR	DER NON-CONFO	PRMANCE	(NCR)			
0750	Description of NC		Corrective Action Sect			Verific	cation	Approval	Approval
SIEP	Section A	Initial Action Description Chief Eng Chief Eng		otion Sign & Date		Section C		Chief Eng	Approval QC Inspector
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	STEP	:PAR #: Resolution: STEP Description of NC	STEP PROCEDURE CH PROCEDURE CH PAR #: Fault Cat Resolution: Dispositi WORK ORI STEP Description of NC Section A Initial	WORK ORDER CH STEP PROCEDURE CHANGE : PAR #: Fault Category: Resolution: Disposition: WORK ORDER NON-CONFO STEP Description of NC Section A Corrective Action Initial Action Description	WORK ORDER CHANGES STEP PROCEDURE CHANGE :PAR #:Fault Category:NCI Resolution:Disposition:QA WORK ORDER NON-CONFORMANCE STEP Description of NC	WORK ORDER CHANGES STEP PROCEDURE CHANGE By :PAR #:Fault Category:NCR: Yes Resolution:Disposition:QA: N/C Clo WORK ORDER NON-CONFORMANCE (NCR STEP Description of NC	WORK ORDER CHANGES STEP PROCEDURE CHANGE By Date :PAR #:Fault Category:NCR: Yes No DQ Resolution:Disposition:QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC	WORK ORDER CHANGES STEP PROCEDURE CHANGE By Date Qty :PAR #: Fault Category: NCR: Yes No DQA: Resolution: Disposition: QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC	STEP PROCEDURE CHANGE By Date Qty Approval Chief Eng Prod Mgr

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Tuesday, October 12, 2010 1:08:04 PM

Work Order ID: 62888

K10003

Parent Item: Parent Item Name:

Saddle, D205-634-011



Location

ST425



Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 4.00

Required Qty: 4.00

D2573	
	, Aft Out 205
	P. 10 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1
PS Saddle	, Aft Out 205

Manufactured No 110

Each

3

10.0000

Loc Code



	D2574	•
\cap		
		Aft In 205

Manufactured No

Manufactured

No

47566 ST434 60706

43566

110 Each

Loc Qty

6.0000

TD2747 Set Screw Location Loc Qty Loc Code ST425 3 43567 ST434 3 60707 3 110 Each 145.0000

Location Loc Qty Loc Code ST023 145 39224 4 59879 41 62085 100

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W/O:			W	ORK ORDER CHANG	ES	l .			•
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Da	te Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No:		PAR #:	Fault Cate	gory:	NCR: Ye	es No DQA: Date:			
Resolution:			Dispositio	n:	_ QA: N/C	Closed	l:	Date: _	
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DATE	STEP	Description of NC			verific			1 Approval	Approval
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Picklist Print Tuesday, October 12, 2010 1:08:04	PM									Page 5
Work Order ID: 62888 Parent Item: K10003 Parent Item Name: Saddle, D205-63	34-011		18 (18 18 18 18 18 18 18 18 18 18 18 18 18 1				art Date: Start Qty:	10/12/2010 4.00		ed Date: 10/22/2010
D2876 Saddle Spacer	Manufactured	No		110	Each	54.0000	2	8		6
1			Location ST026 60853 ST028	<u>Lo</u> :	49 49 5 5	Loc Code		60883		
D2877 Saddle Spacer	Manufactured	No		110	Each	65.0000	12	8		6
			Location ST026 60854 61211	<u>Lo</u>	65 24 41	Loc Code		6055	•	
D3405-041 ' Lug Assembly	Manufactured	No		110	Each	8.0000	1	61990	<u></u>	<u> </u>
7			<u>Location</u> ST474 60495	<u>Lo</u>	8 8	Loc Code				
D3405-043	Manufactured	No		110	Each	2.0000		6020	5	lef4/2 (
			Location ST474 53888 56514	<u>Lo</u>	2 1 1	Loc Code				

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W/O:			ES				•			
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC-Inspector	
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Part No:		PAR #:	Fault Cat	egory:	NCR: Yes	No DQ	A:	A: Date:		
Resolution:						1				
NCR:			WORK ORI	DER NON-CONFORMA	NCE (NC	R)				
DATE	OTED.	Description of NC		Corrective Action Section		Verifi	Verification A		Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat	& Sec	ion C	Approval Chief Eng	QC inspector	
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Picklist Print Tuesday, October 12, 2010 1:08:04 PM Work Order ID: 62888 Parent Item: K10003 Parent Item Name: Saddle, D205-634-011 **Required Date: 10/22/2010 Start Date:** 10/12/2010 Start Qty: 4.00 Required Oty: 4.00 D3407-041 Manufactured No 110 Each 13.0000 Location Loc Qty Loc Code ST464 13 59632 2 61219 11 D3417-5 Manufactured No 110 Each 37.0000 Location Loc Qty Loc Code ST056 37 60297 37 Manufactured 110 Each 17.0000 No Location Loc Oty Loc Code ST058 17 54692 17 D3533-1 110 Each 39.0000 Manufactured No

Set Screw

 Location
 Loc Oty
 Loc Code

 ST069
 39

 51602
 39

5/602

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W/O:			WORK ORDER (CHANGES	i			· · · · ·
DATE	STEP	PR	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	·:	PAR #:	Fault Category:	NCR : Ye	s No DG	A:	_ Date: _	
	Resolution:		Disposition:	QA: N/C	Cľosed:		Date: _	

NCR:			WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC	Corrective Action Section B			Verification	Annaval	Annaval			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC inspector			
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Tuesday, October 12, 2010 1:08:04	1 PM				
Work Order ID: 62888					4
Parent Item: K10003					
Parent Item Name: Saddle, D205-6	34-011	1 (00.001) 00. 1101/ 00.// 00.// 00.// 00.00		Start Date: 10/12/2010 Start Qty: 4.00	Required Date: 10/22/2010 Required Qty: 4.00
MS21042L4	Purchased	No	110 Each	4,050.000 24 96	
		Location	Loc Oty	Loc Code	
		ST300	4050		
		113422	68		
		114523 114718	8 16		- ,
		114784	32		
		115108	926		
		115589	1900	M11 S	<u>C</u> 87
		115621	1100		
MS21043-4	Purchased	No .	110 Each	739.0000 5 20	
		Location	Loc Oty	Loc Code	,
		FG	40		

<u>Location</u>	Loc Oty	Loc Code	
FG	40		
104603	40		
ST301	699		
112492	25		
113069	8		
114523	366		M114523
114784	300		

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W/O:			W	ORK ORDER CHANGES					•
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	egory: I	NCR: Yes	No DQ	A :	_ Date: _	
	R	esolution:	Dispositi	on: (A: N/C C	osed:		Date: _	
NCR:		V	VORK ORE	DER NON-CONFORMAN	CE (NCR)			
DATE	STEP	Description of NC	Corrective Action Section B			Verific	ation	Approval	Approval
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D205-634

Page 10 of 10

5.0 **PARTS LIST**

ltem	634 -011	634 -015	634 -041	634 -045	641 -011	Part Number	Description
	X	V.		<u> </u>		D205-634-011	SKIDTUBE INSTALLATION (STANDARD)
		Х			Ì	D205-634-015	SKIDTUBE INSTALLATION (MODIFIED)
	1		Х			D205-634-041	SKIDTUBE
		1		Х		D205-634-045	SKIDTUBE
	1	1			X	D205-641-011	GROUND HANDLING KIT
1			1			D2580-041	205 SKIDTUBE ASSEMBLY (STANDARD)
- 		-	!	1		D2580-041	205 SKIDTUBE ASSEMBLY (MODIFIED)
2A			16	16		D2594-1	* PLUG
2B		ļ	16	16		D2594-3	* O-RING
3			1	1		D2855	* AFT CAP
4			2	2		AN3-5A	* BOLT
5			2	2		AN960JD10L	* WASHER
6A			1	1		D3564-9	* WEARSHOE (REPLACES D2577-1)
6B			1	1		D3566-1	* GASKET
7A			1	1		D3564-11	* WEARSHOE (REPLACES D2577-3)
7B			1	1		D3566-1	* GASKET
8A			1	1		D3564-5	* WEARSHOE (REPLACES D2577-5)
8B			1	1		D3566-5	* GASKET
9A			1	1		D3564-13	* WEARSHOE
9B			1	1		D3566-13	* GASKET
10			50	50		AN3C4A	* BOLT (REPLACES AN3-4A)
11			50	50		AN960C10L	* WASHER (REPLACES AN960JD10L)
12			50	50		ALS4-1032-130	* INSERT
13			2	. 2		ALS4-1032-225	* INSERT
20	1	1				D2571	SADDLE, FWD OUTSIDE
21	1	1				D2572	SADDLE, FWD INSIDE
22	1	1				D2572	SADDLE, AFT OUTSIDE
23	1	1			<u> </u>	D2574	SADDLE, AFT INSIDE
24	8	8			-	AN4-51A	BOLT
25	16	16				D2570	BUSHINGS
26	8	8				MS21042L4	NUT (OR MS21042-4)
27	8	8				AN6-12A	BOLT
28	8	8				AN960JD616	WASHER
29	16	16				AN4-6A	BOLT
30	32	32				AN960JD416	WASHER
31	16	16				MS21042L4	NUT (OR MS21042-4)
32	4	4				D2747	SET SCREW
33	2	2				D3533-1 /	SET SCREW
							TOW PINC (PERI ACEC POOCS 044)
40	1	1					TOW RING (REPLACES D2968-041)
41	1	1				D3430-1	WASHER
43	1	1				MS21043-4	NUT
44	2	2				D3417-5 /	WASHER
50				<u></u>	1.	D3405-041	LUG ASSEMBLY (REPLACES D2736-1)
51					1	D3405-043	LUG ASSEMBLY (REPLACES D2736-3)
52					4	AN4C47A	BOLT
53	-	-			8	D2570	BUSHING
54	i		<u> </u>		4	MS21043-4	NUT (OR MS21042-4)
60	2	2				D2876	SADDLE SPACER
61	2	2		L		D2877	SADDLE SPACER

*DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

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Revision: F

Date: 08.10.07